

5/25


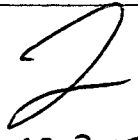

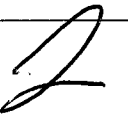
DART AEROSPACE LTD	Work Order: 23520 D3393-041
Description: Dual Disabling Kit (Medium Bell)	Part Number: D412-738-041
	Keyed: <input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3368 Rev. B; D3369 Rev. A1 page 4; D3371 Rev. B page 4; D3393 Rev. A page 1	Qty: 20 32 Page 1 of 3

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	DP	05.06.08	32																				
2	DC	Photocopy bluefile and create labels per PPP D412-738-041 CHG002 WK 23	DP	05/06/14	20																				
3	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td>B22554</td> </tr> <tr> <td>1</td> <td>D3373-1</td> <td>Cam Lock B22175</td> <td>D3373 HKA B23643</td> </tr> <tr> <td>1</td> <td>D3393-1</td> <td>Battery Lock Casing</td> <td>B23552</td> </tr> <tr> <td>1</td> <td>D3393-3</td> <td>Cam Lock Shaft</td> <td>B22941B</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	B22554	1	D3373-1	Cam Lock B22175	D3373 HKA B23643	1	D3393-1	Battery Lock Casing	B23552	1	D3393-3	Cam Lock Shaft	B22941B	SAD	06/06/29	32
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	B22554																						
1	D3373-1	Cam Lock B22175	D3373 HKA B23643																						
1	D3393-1	Battery Lock Casing	B23552																						
1	D3393-3	Cam Lock Shaft	B22941B																						
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	SAD	05/06/27	32																				
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5	SAD	05/06/27	32																				
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-5</td> <td>Washer B22175</td> <td>M17197</td> </tr> <tr> <td>2</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td>M17197</td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td>M16517</td> </tr> </tbody> </table> Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer B22175	M17197	2	5/16WC	SS Flat Washer	M17197	A/R	N/A	262 Locktite	M16517	SAD	06/06/27	32				
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer B22175	M17197																						
2	5/16WC	SS Flat Washer	M17197																						
A/R	N/A	262 Locktite	M16517																						
7	WS	Tack Weld lock shaft to flat cam Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>SS Rod</td> <td>NA</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod	NA	PD	05-06-27	32												
Qty	Part Number	Description	Batch																						
A/R	N/A	SS Rod	NA																						
8	GA	Apply crazy glue to caps then press caps into body. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>9567K21</td> <td>Polyethelene Cap</td> <td>M17089</td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Krazy Glue</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap	M17089	A/R	N/A	Krazy Glue		SAD	06/06/29	32								
Qty	Part Number	Description	Batch																						
2	9567K21	Polyethelene Cap	M17089																						
A/R	N/A	Krazy Glue																							
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3368-1</td> <td>Pedal Lock Base</td> <td></td> </tr> <tr> <td>1</td> <td>D3368-3</td> <td>Pedal Lock Cover</td> <td></td> </tr> </tbody> </table> Identify as D3368-051	Qty	Part Number	Description	Batch	1	D3368-1	Pedal Lock Base		1	D3368-3	Pedal Lock Cover												
Qty	Part Number	Description	Batch																						
1	D3368-1	Pedal Lock Base																							
1	D3368-3	Pedal Lock Cover																							
10	QC3	Inspect Powder Coat																							

(86) OCS Inspect work to step 8

 RELEASED
 7050742 32
 11/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-13	7	one scrap key does not turn lock got tacked inside, causing it to not turn		Scrap lock	u	 05-07-13	 05-07-13	 05-07-13

Part No: D412-738-011 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/07/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23520
Description: Dual Disabling Kit (Medium Bell)		Part Number:	D412-738-041
		Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3368 Rev. B; D3369 Rev. A1 page 4; D3371 Rev. B page 4; D3393 Rev. A page 1		Qty:	2032
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																												
11	GA	<p>Press dowel pins into D3368-3 pedal lock cover, then assemble hinge as per Dwg D3368. Apply 262 Locktite into all threaded holes/screws.</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-7</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>1</td> <td>D3385-3</td> <td>Hinge</td> <td></td> </tr> <tr> <td>3</td> <td>238-028</td> <td>Ø3/16" Dowel Pin 1/2" long</td> <td></td> </tr> <tr> <td>4</td> <td>385-039</td> <td>Flat Head Screw</td> <td></td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-7	Cam Lock		1	D3385-3	Hinge		3	238-028	Ø3/16" Dowel Pin 1/2" long		4	385-039	Flat Head Screw		A/R	N/A	262 Locktite				
Qty	Part Number	Description	Batch																														
1	D2728-7	Decal																															
1	D3373-7	Cam Lock																															
1	D3385-3	Hinge																															
3	238-028	Ø3/16" Dowel Pin 1/2" long																															
4	385-039	Flat Head Screw																															
A/R	N/A	262 Locktite																															
12	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.																															
13	GA	Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5																															
14	GA	<p>Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	262 Locktite																								
Qty	Part Number	Description	Batch																														
A/R	N/A	262 Locktite																															
15	GA	<p>Assemble lanyard to cyclic sock as per Dwg D3384</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td></td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td></td> </tr> <tr> <td>28"</td> <td>CBL-1240</td> <td>Cable</td> <td></td> </tr> </tbody> </table> <p>Identify as D3384-047</p>	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		28"	CBL-1240	Cable																
Qty	Part Number	Description	Batch																														
1	D3384-1	Cyclic Sock																															
2	CBL-460	Loop Sleeve																															
28"	CBL-1240	Cable																															
16	GA	<p>Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368.</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td></td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>1/4"-20 SHCS 3/8" long</td> <td></td> </tr> </tbody> </table> <p>Identify as D3368-041 & attach keys Record the Key Number on page 3</p>	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	1/4"-20 SHCS 3/8" long																				
Qty	Part Number	Description	Batch																														
2	AN960-416	Washer																															
1	HX-81	1/4"-20 SHCS 3/8" long																															
17	QC5	Inspect work to Step 16																															
18	PK	<p>Ensure that keys are attached to D3368-041 and D3393-041</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3368-041</td> <td>Pedal Lock Assembly</td> <td></td> </tr> <tr> <td>1</td> <td>D3393-041</td> <td>Battery Lock Assembly</td> <td></td> </tr> </tbody> </table> <p>Ensure that keys can be locked and unlocked for each D3368-041 and D3393-041 assembly.</p>	Qty	Part Number	Description	Batch	1	D3368-041	Pedal Lock Assembly		1	D3393-041	Battery Lock Assembly																				
Qty	Part Number	Description	Batch																														
1	D3368-041	Pedal Lock Assembly																															
1	D3393-041	Battery Lock Assembly																															
19	QC4	Inspect Kit 100% for Completeness on the W/O																															
20	PK	Identify and pack for shipping as per PPP D412-738-011 ID + Stock D3393-041 B23526																															
21	AC	<p>Cost / part: 609.10 613.54</p>																															

RELEASED
11/15/05:25

C2 05/07/12 31
AP 05/07/12 32
05/07/12 33

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

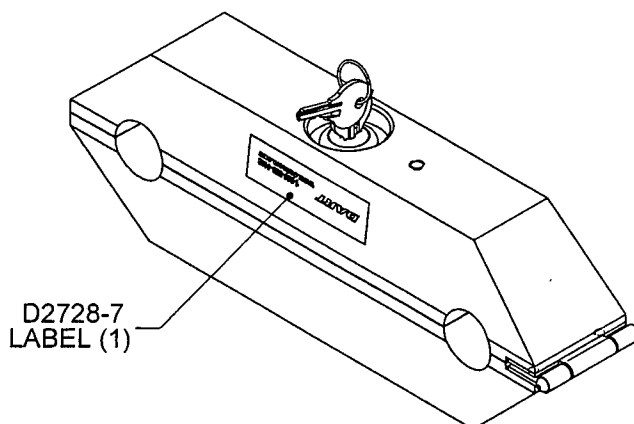
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

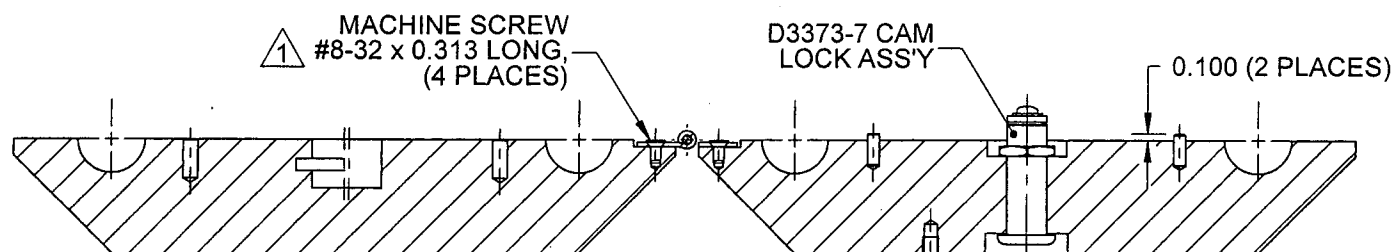


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CHECKED RT	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

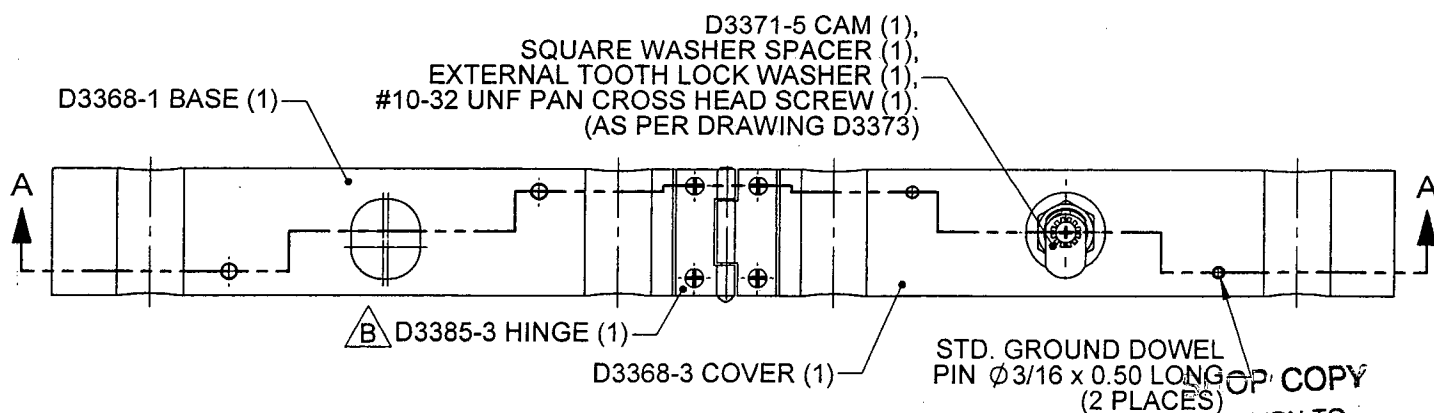


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[Signature]
25/04/28

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAUR P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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SUSPECTED
WITH COPY

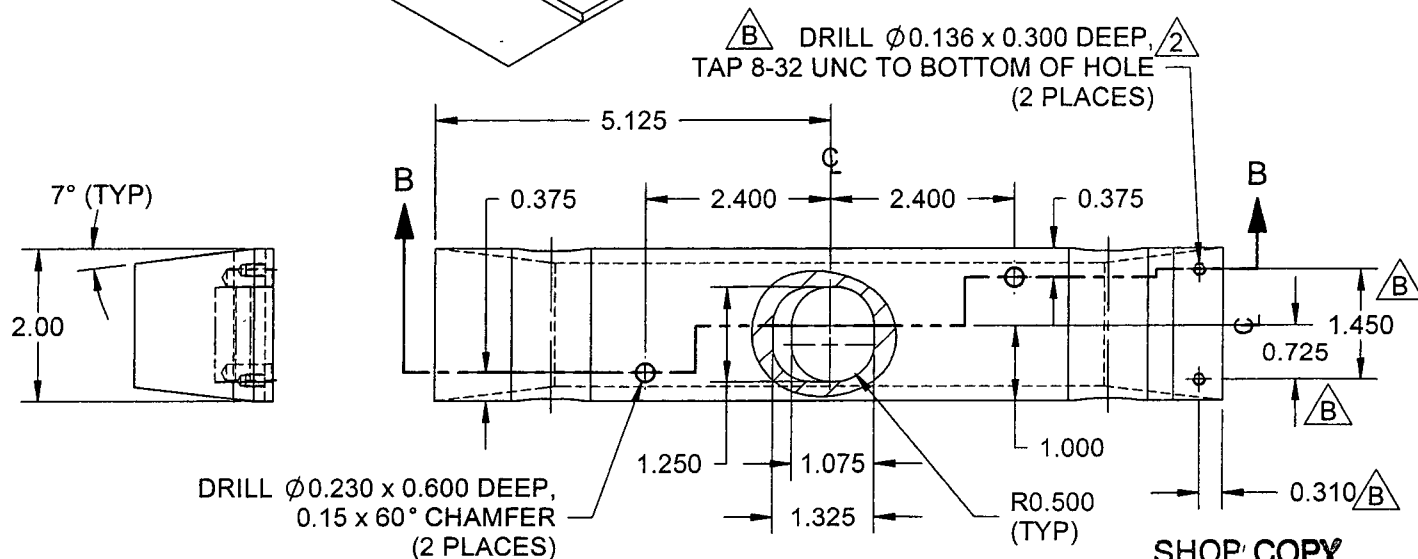
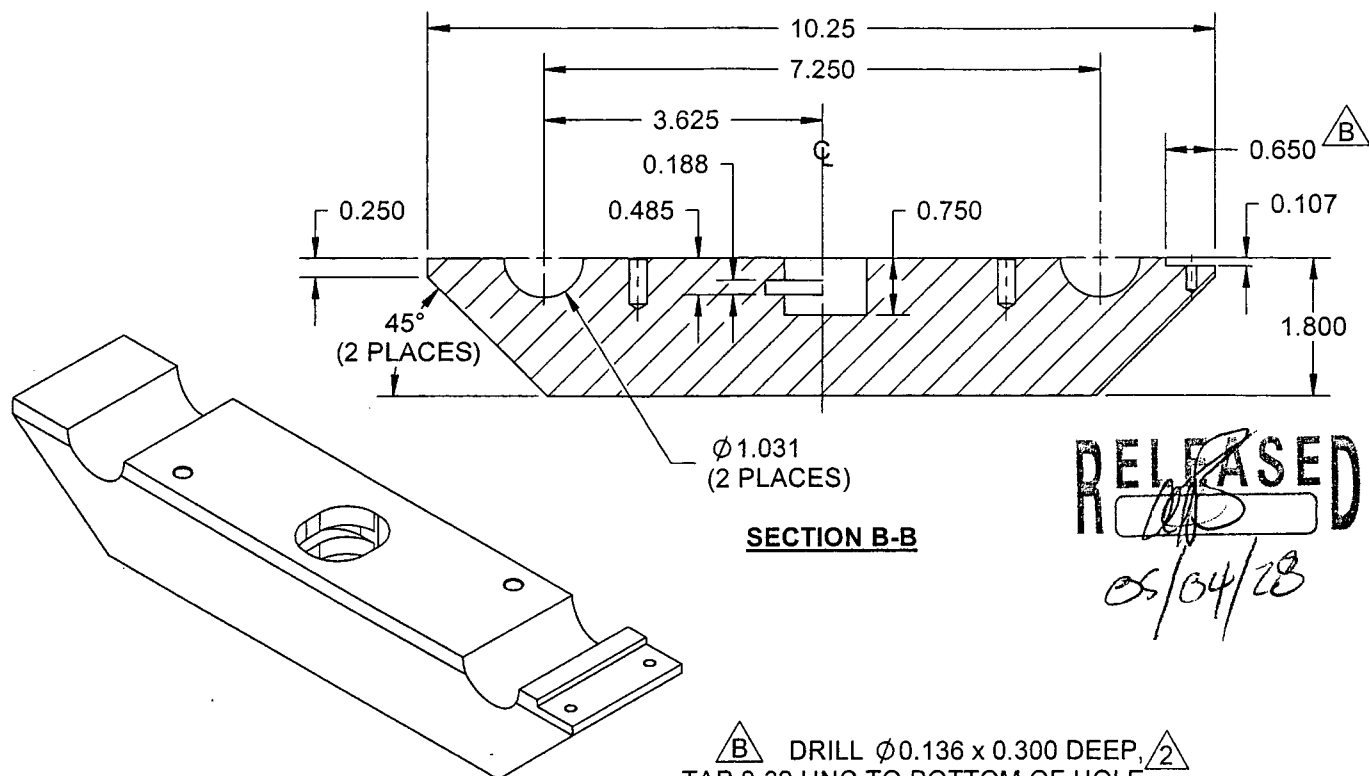
WORK ORDER
NO. 23520

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER

NO. 23520

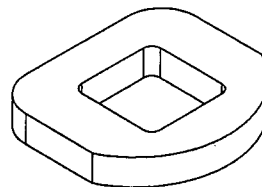
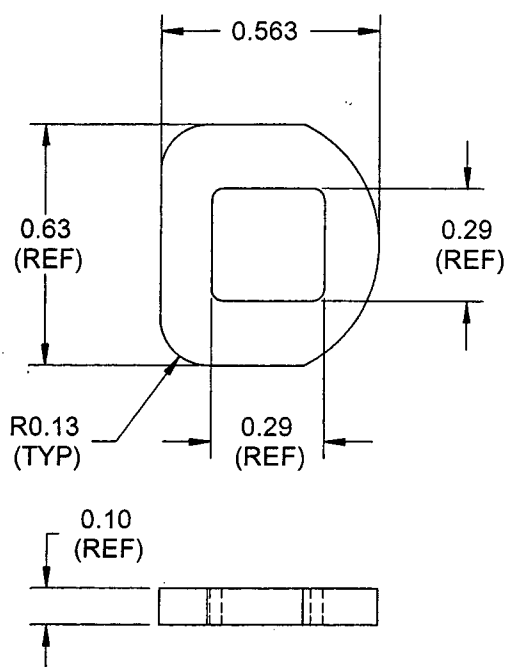
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DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>7F</i>	APPROVED <i>AKS</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
AKS

05/02/11

-5
D3369 SPACER



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WITHOUT NOTICE

WORK ORDER

NO. 23520

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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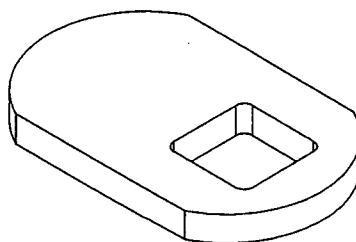
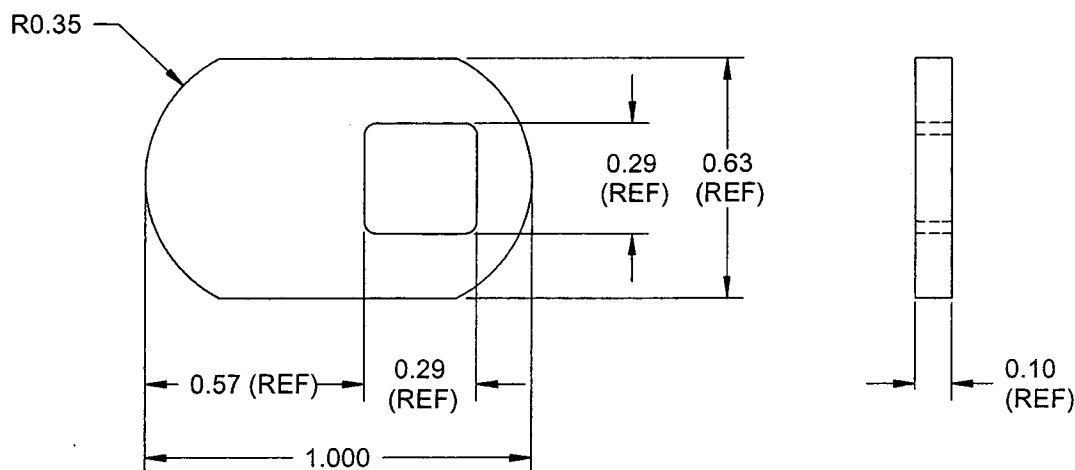
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 23520

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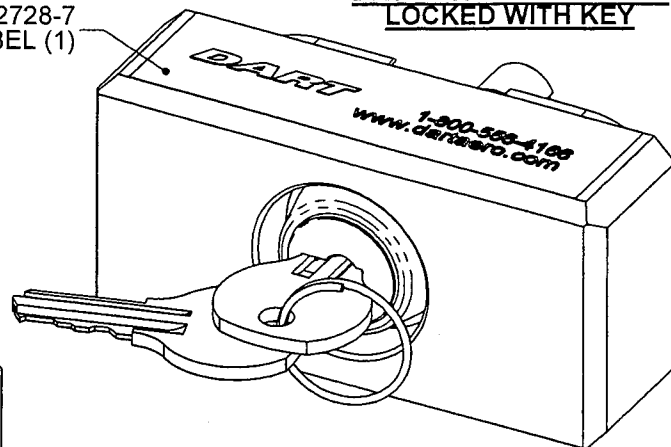
DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED

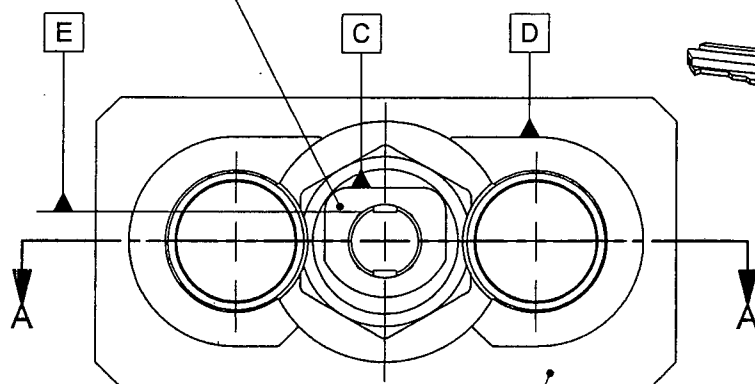
05/03/09

BATTERY LOCK SHOWN
LOCKED WITH KEY

D2728-7
LABEL (1)



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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WORK ORDER

NO. 23520

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 07, 2005
11:56 am

Work Order No : 0023520
Project Name : D412-738-011
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : *D412-738-011
Description : Dual Disabling Kit
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 06-07-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00